

VISIT...

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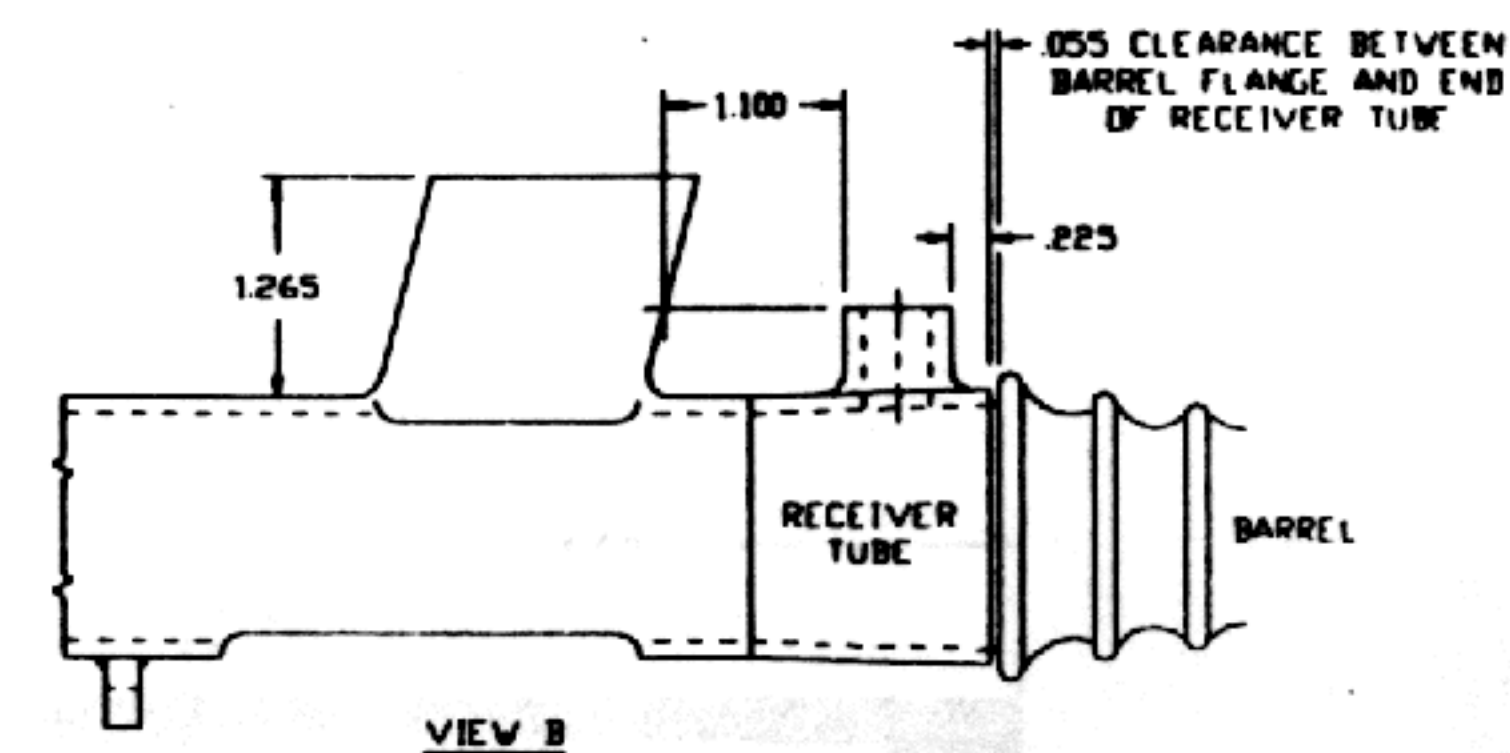
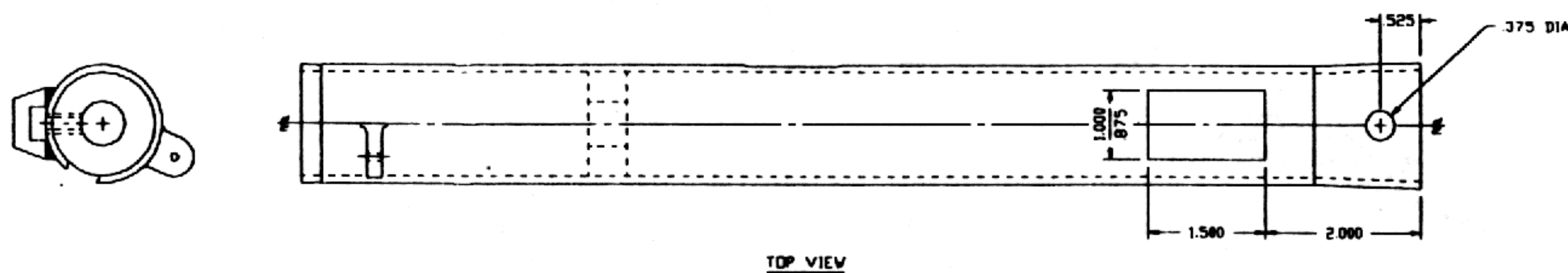
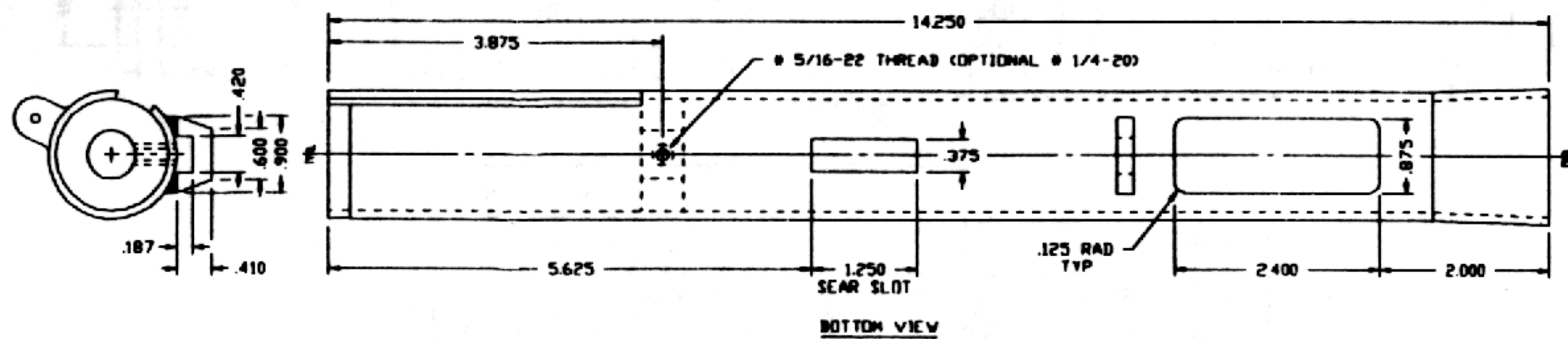
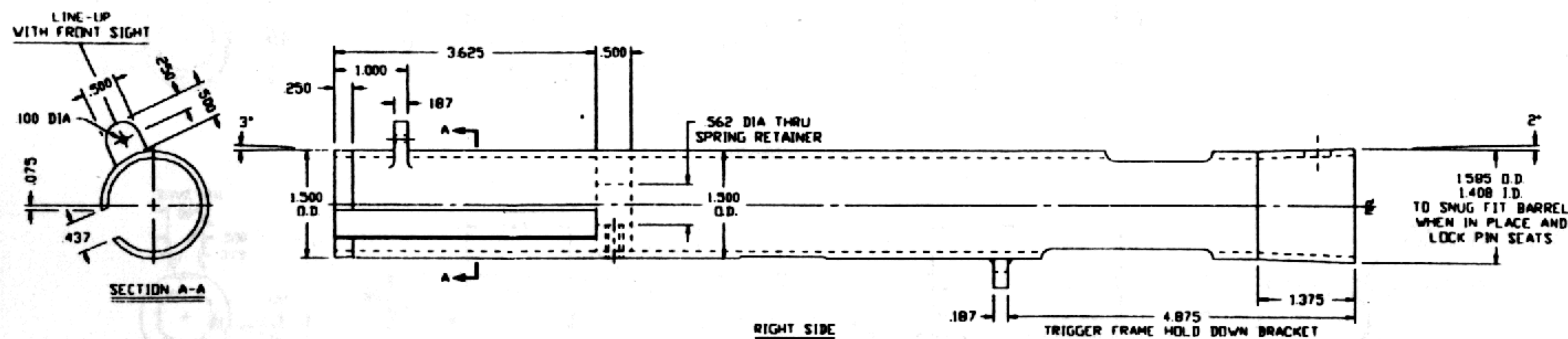
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1- scale print of REISING

1- scale print of SPRINGFIELD M-60 lt. MG

PARTS SUPPLIERS ON LAST PAGE



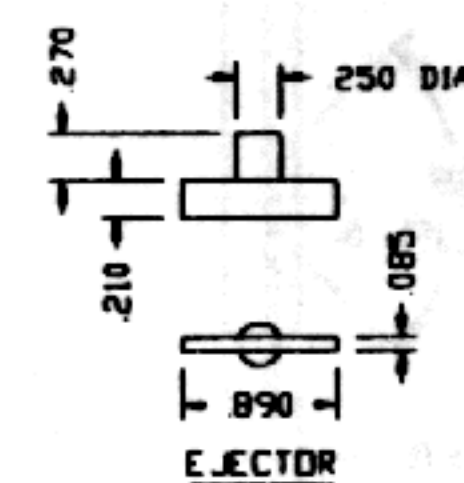
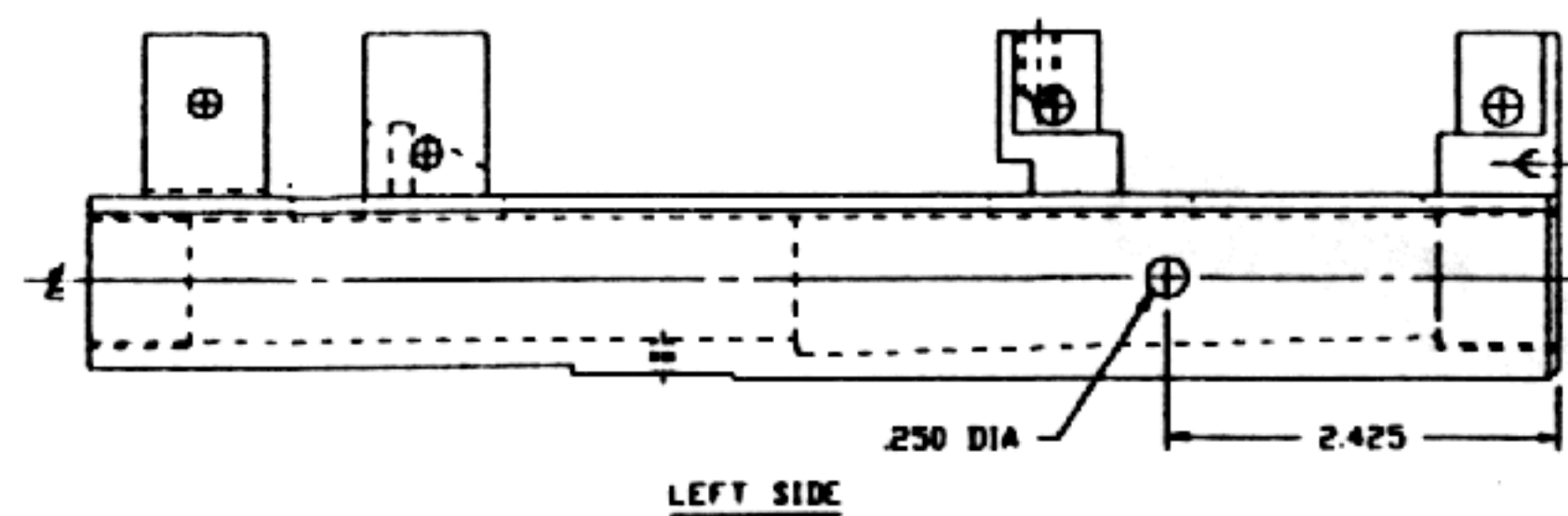
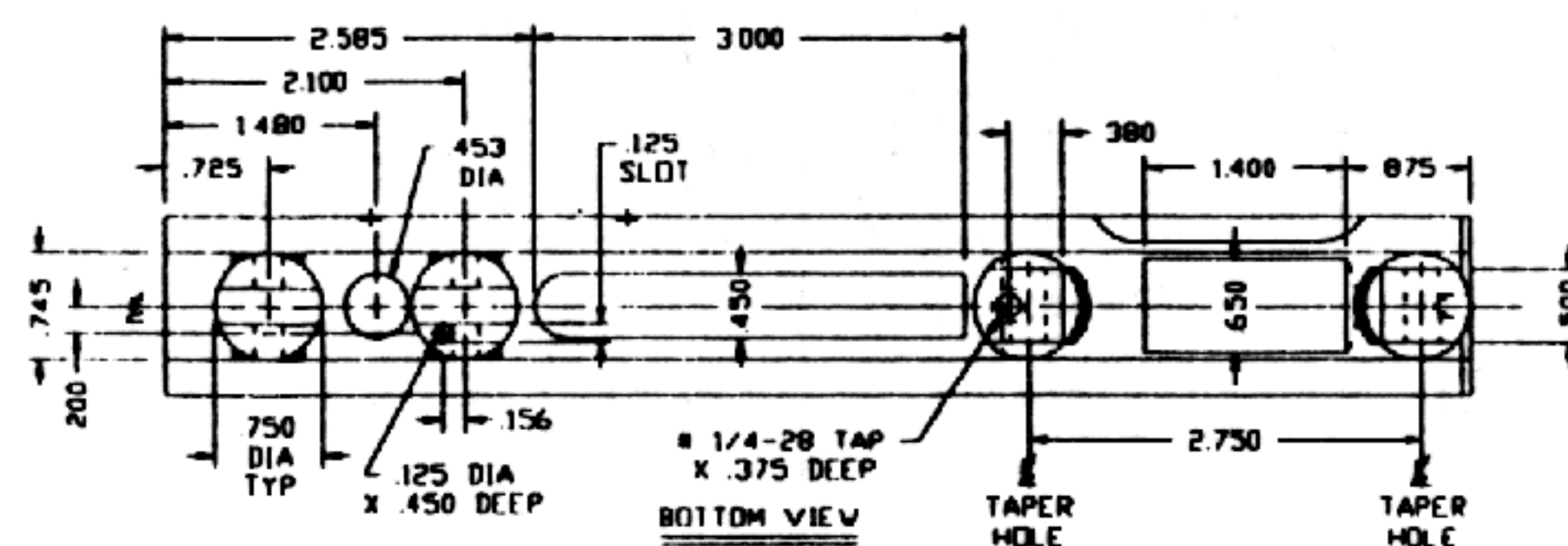
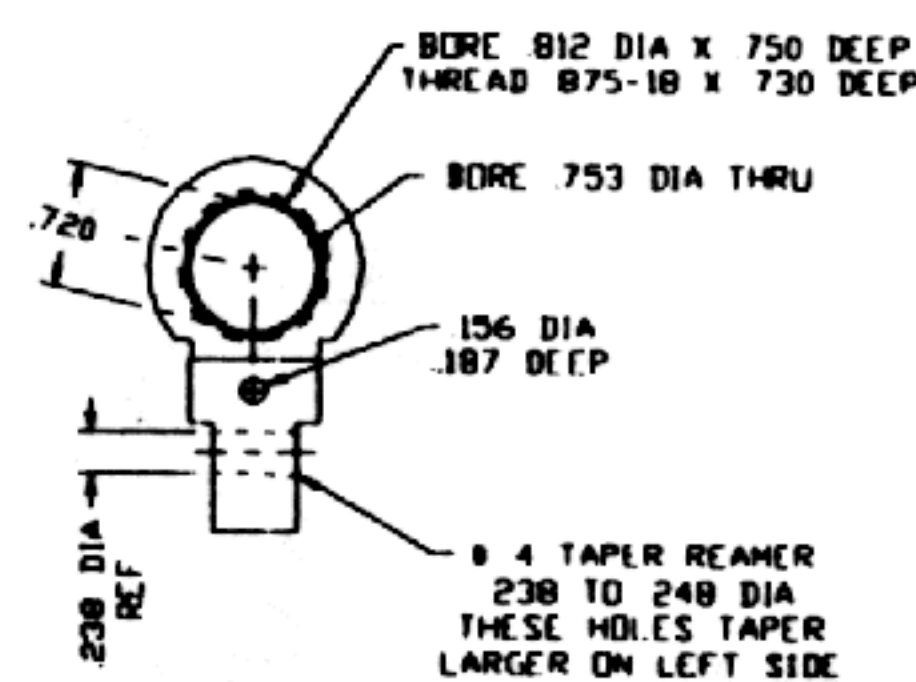
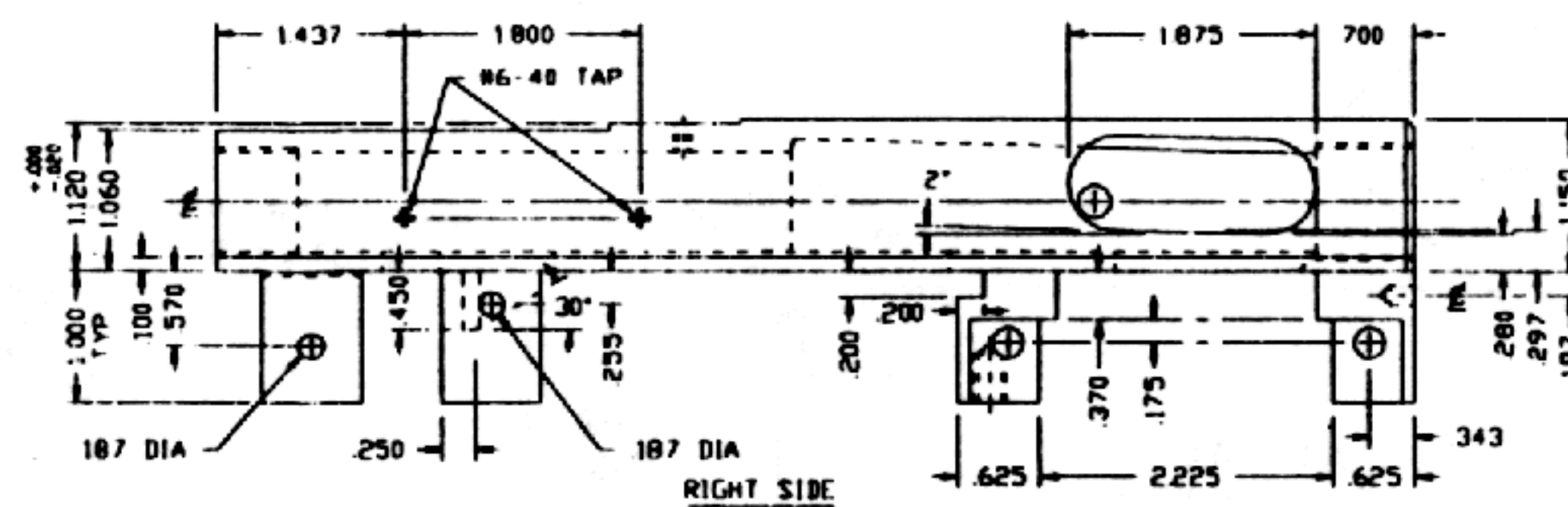
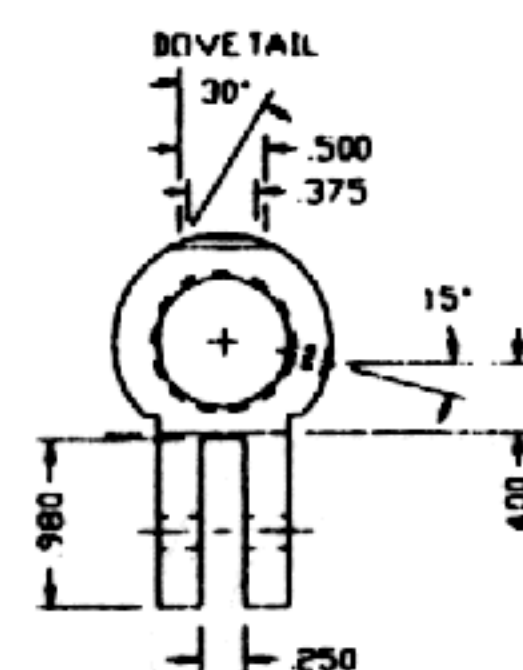
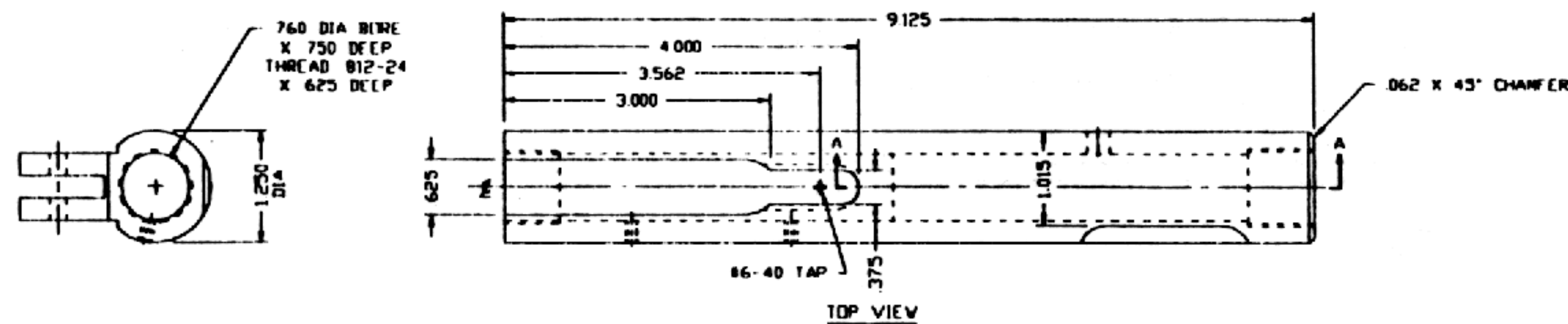
NOTES

1. MATERIAL- 1625 O.D. X 1.312 I.D. DDM STEEL TUBE
2. FINISH- PAKERIZE THEN PAINT BLACK OR CAMOFLAGE
3. SOME PART KITS COME WITH FRONT RECEIVER PARTS IN TACT. IF THIS IS YOUR CASE, THEN REAR PART OF RECEIVER TUBE CAN BE ALIGNED AND BUTT WELDED.
4. IF PARTS ARE LOOSE, REFER TO 'VIEW B' FOR THEIR LOCATION
5. Ø 5/16-22 THREAD IS BRITISH AND CAN BE SUBSTITUTED WITH Ø 7 DRILL (.201 DIA) AND TAP Ø 1/4-20 THREAD. REPLACE ORIGINAL Ø 5/16 SCREW WITH Ø 1/4-20 ROUND HEAD SCREW
6. SPRING RETAINER IS 1.312 O.D. WITH .562 DIA HOLE IN CENTER AND .500 WIDE. WELD IN PLACE USING 3 OR 4 DRILLED HOLES EQUALLY SPACED IN RECEIVER TUBE AT 3.875 DIMENSION AFTER ARC WELDING SPRING RETAINER AND RECEIVER TUBE TOGETHER DRILL AND TAP Ø 1/4-20 HOLE IN BOTTOM FOR TRIGGER FRAME HOLD DOWN SCREW.
7. WHEN 3" TAPER IS CUT ON REAR OF RECEIVER TUBE IT SHOULD MEASURE 1.400 AT SMALL END. MUST COVER FITS IN PLACE OVER THIS TAPER.
8. EARLY MODEL BARRELS WERE FINISHED. LATE MODEL BARRELS WERE PLAIN.

**RESTRICTED
MATERIAL**

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SCALE	FULL	MATERIAL	SEE NOTE 1	CBS	TOLERANCES
DWG		FINISH	SEE NOTE 2	DATE	DEC 2 PL 1/2
TITLE	OVEN MK II MODEL 1943 RECEIVER			REV.	DEC 2 PL 1/2
					ANGLES ± .01



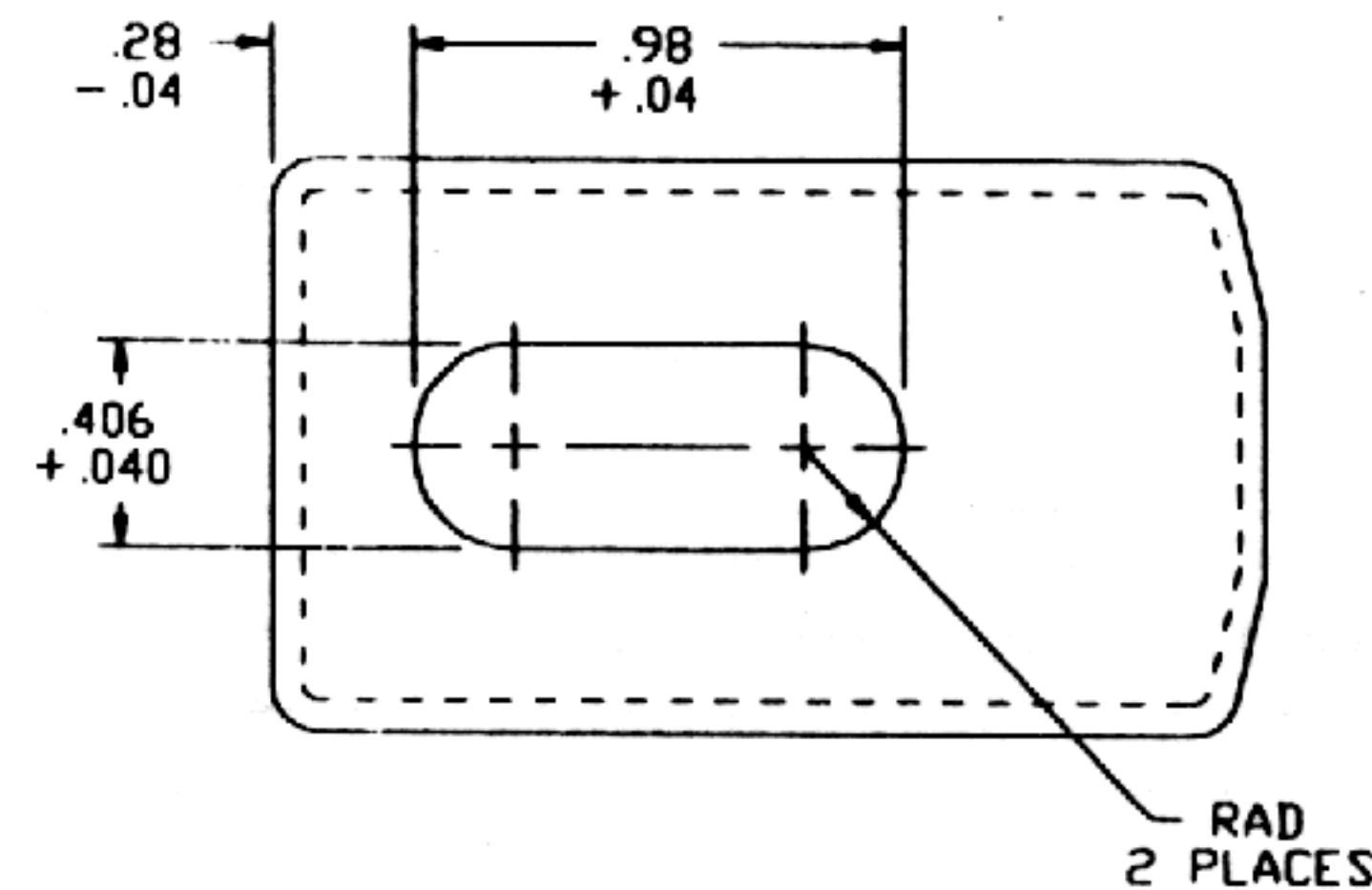
NOTES:

1. MATERIAL - 1020 STEEL DOM TUBING
2. FINISH - MILITARY 30 PARKERIZE, CIVILIAN 30 OR 60 BLUE
3. DARKENED AREAS AROUND 750 DIA POST REPRESENT ELECTRIC WELDS AFTER POSTS HAVE BEEN BRAZED OR SILVER BRAZED IN PLACE JUST LIKE ORIGINAL RECEIVER
4. 375 AREA OF SIGHT SLOT IS UNDERCUT WITH A 60° DOVETAIL CUTTER
5. EJECTION PORT IS ANGLED TO RESULT IN .280 DIMENSION IN FRONT AND 297 IN REAR
6. BORE OR REAM 753 DIA THRU HOLE BEFORE CUTTING OFF SET
7. SEMI AUTOMATIC RECEIVER CAN BE ACCOMPLISHED BY NOT CUTTING 125 SLOT WITH 30° RAMP AND .125 HOLE X .450 DEEP THIS WILL NOT ALLOW DISCONNECTOR TO BE ASSEMBLED

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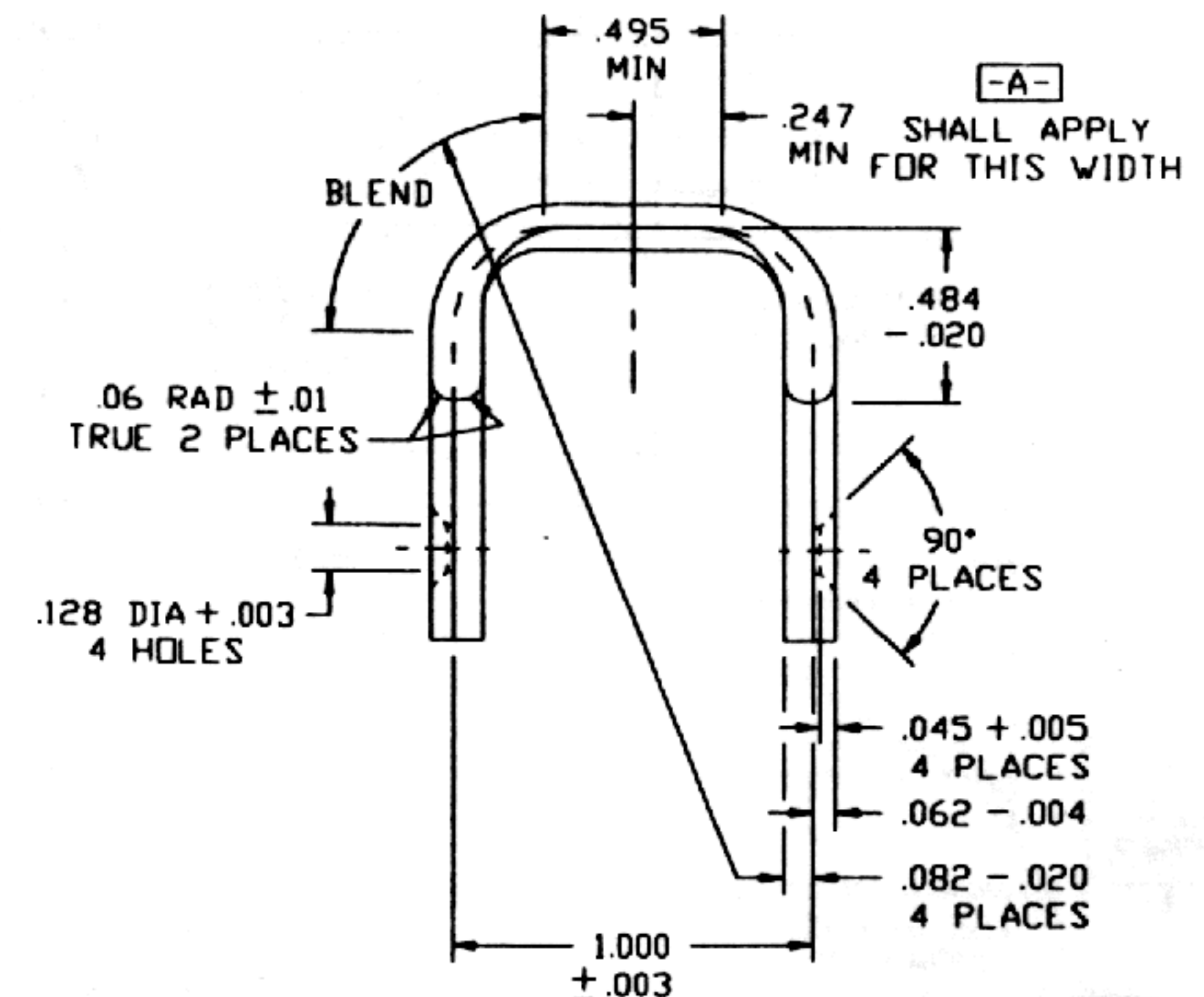
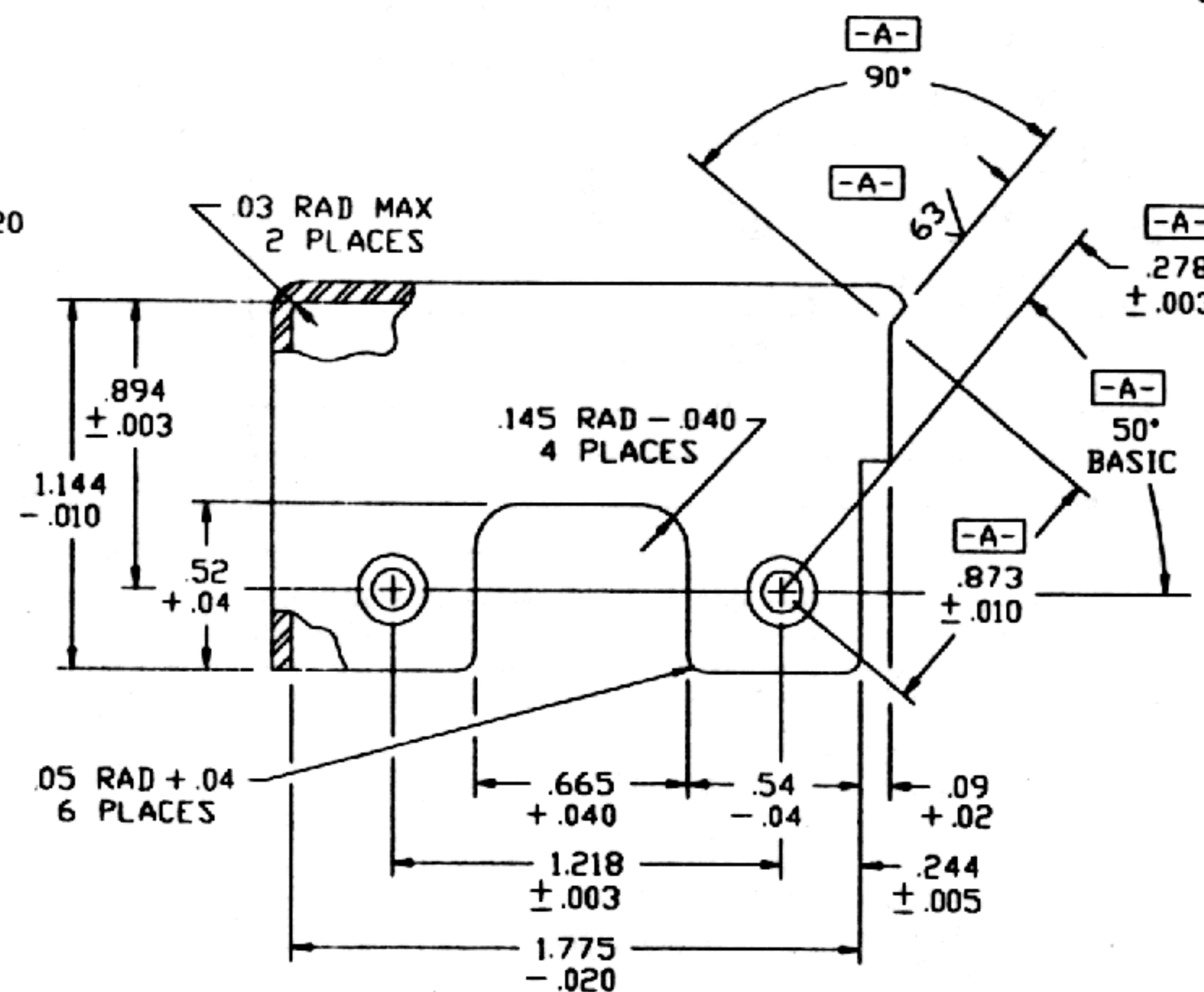
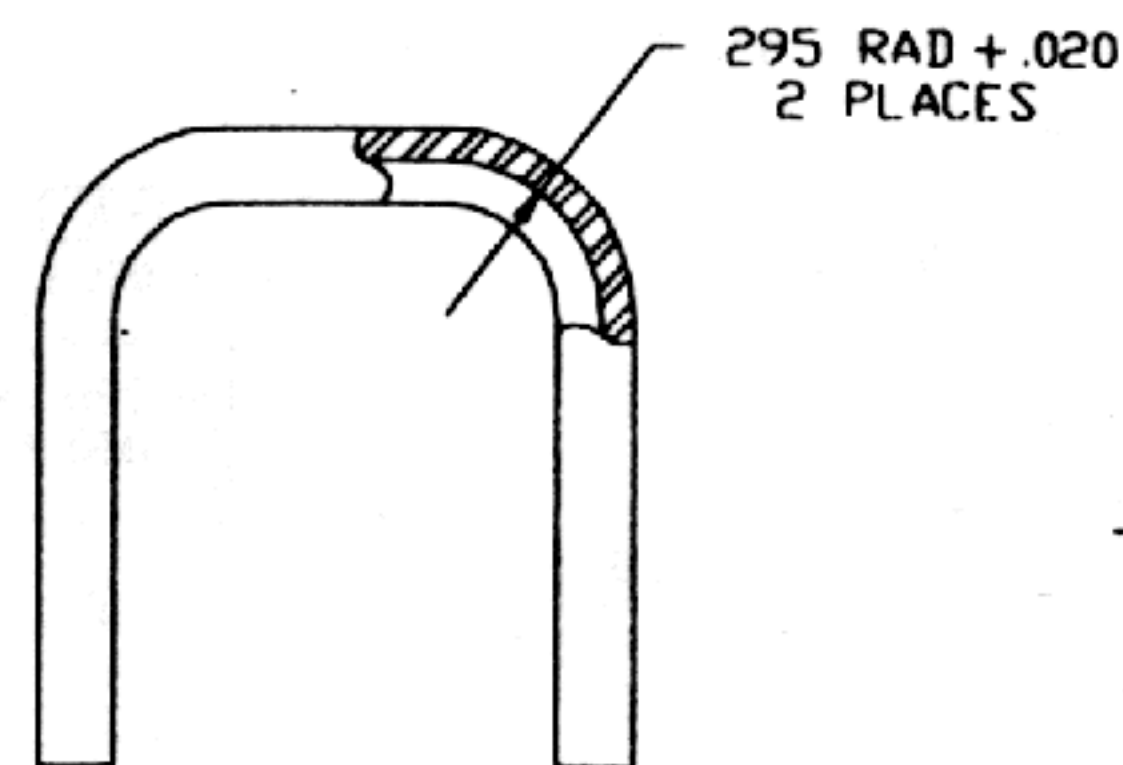
**RESTRICTED
MATERIAL**

SCALE	FULL	MATERIAL	SEE NOTE 1	DES		TOLERANCES
DATE		FINISH	SEE NOTE 2	DATE		REC'D: 51
TITLE				REV.		REC'D: 80
						INCHES: 8"
						NO



NOTES:

1. FINISH $\sqrt{125}$ EXCEPT AS NOTED. SHEARED SURFACES $\sqrt{250}$.
2. ALL EDGES SHALL BE BROKEN .005 $\pm$.010 UNLESS OTHERWISE SPECIFIED.
3. MATERIAL- STEEL QQ-S-698 CARBON .17 TO .24, MANGANESE .30 TO .60 DRAWING QUALITY KILLED.
4. HEAT TREATMENT- CARBURIZE AT 1600°F FOR .005 TO .010 CASE DEPTH. OIL QUENCH. TEMPER 30 MINUTES AT 350°F. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENT ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED. THE USE OF STRAIGHT CYANIDE BATH OR CARBONITRIDING PROCESS SHALL NOT BE PERMITTED WITHOUT PRIOR APPROVAL OF THE CONTRACTING OFFICER.
5. FILEHARD TEST IN ACCORDANCE WITH SA-STD-104. (H1)
6. FINAL PROTECTIVE FINISH 5.3.1.2 OF MIL-STD-171



RESTRICTED
MATERIAL

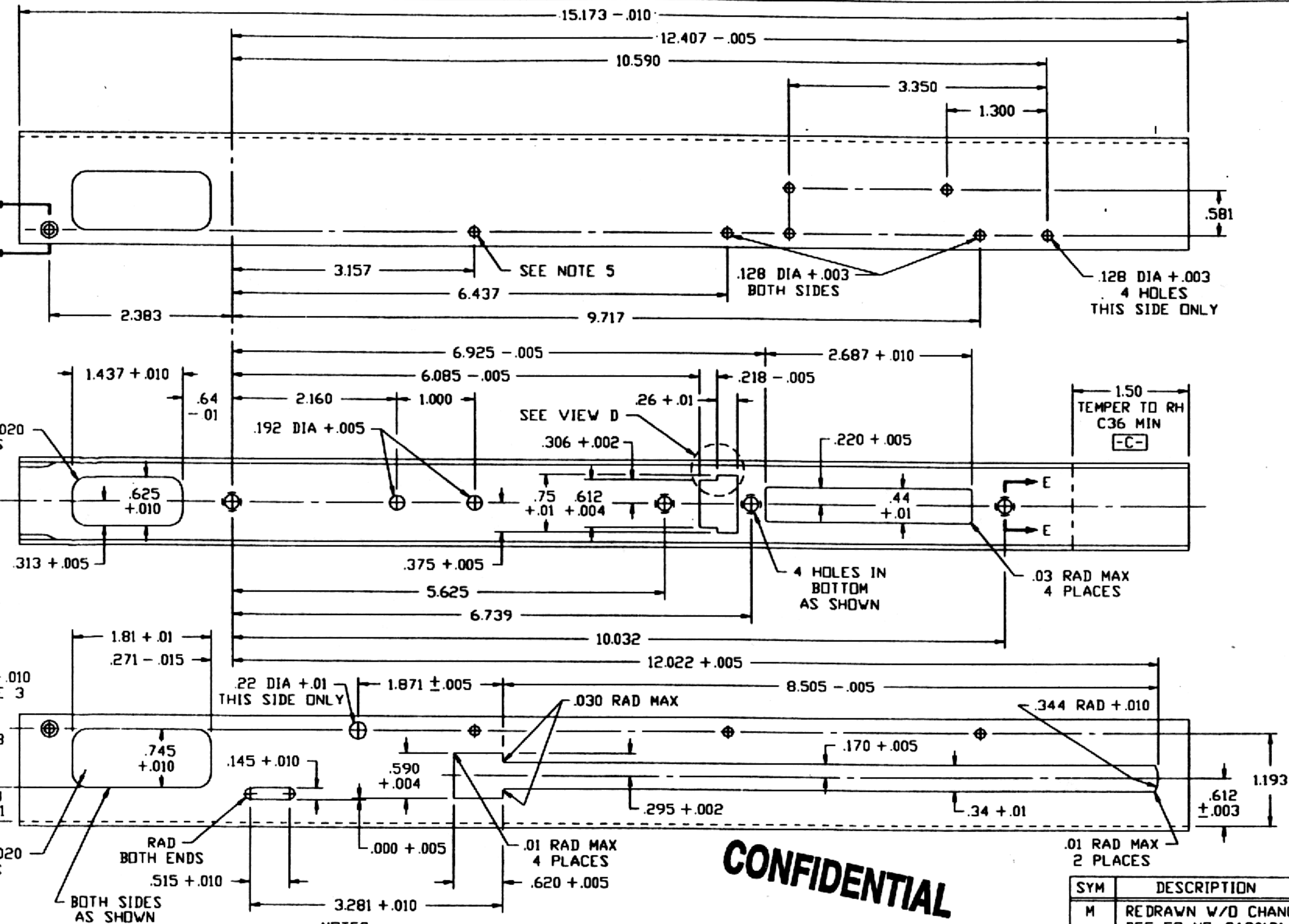
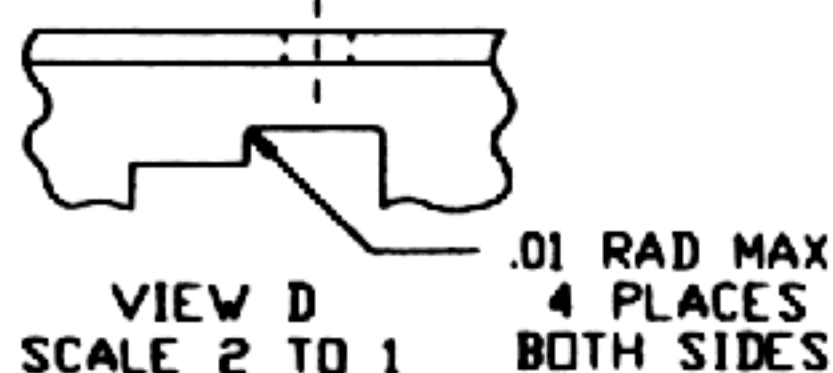
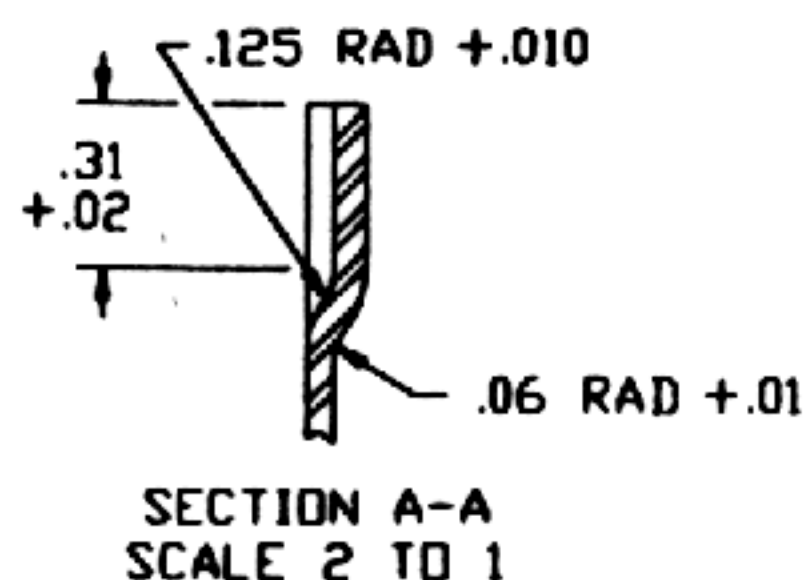
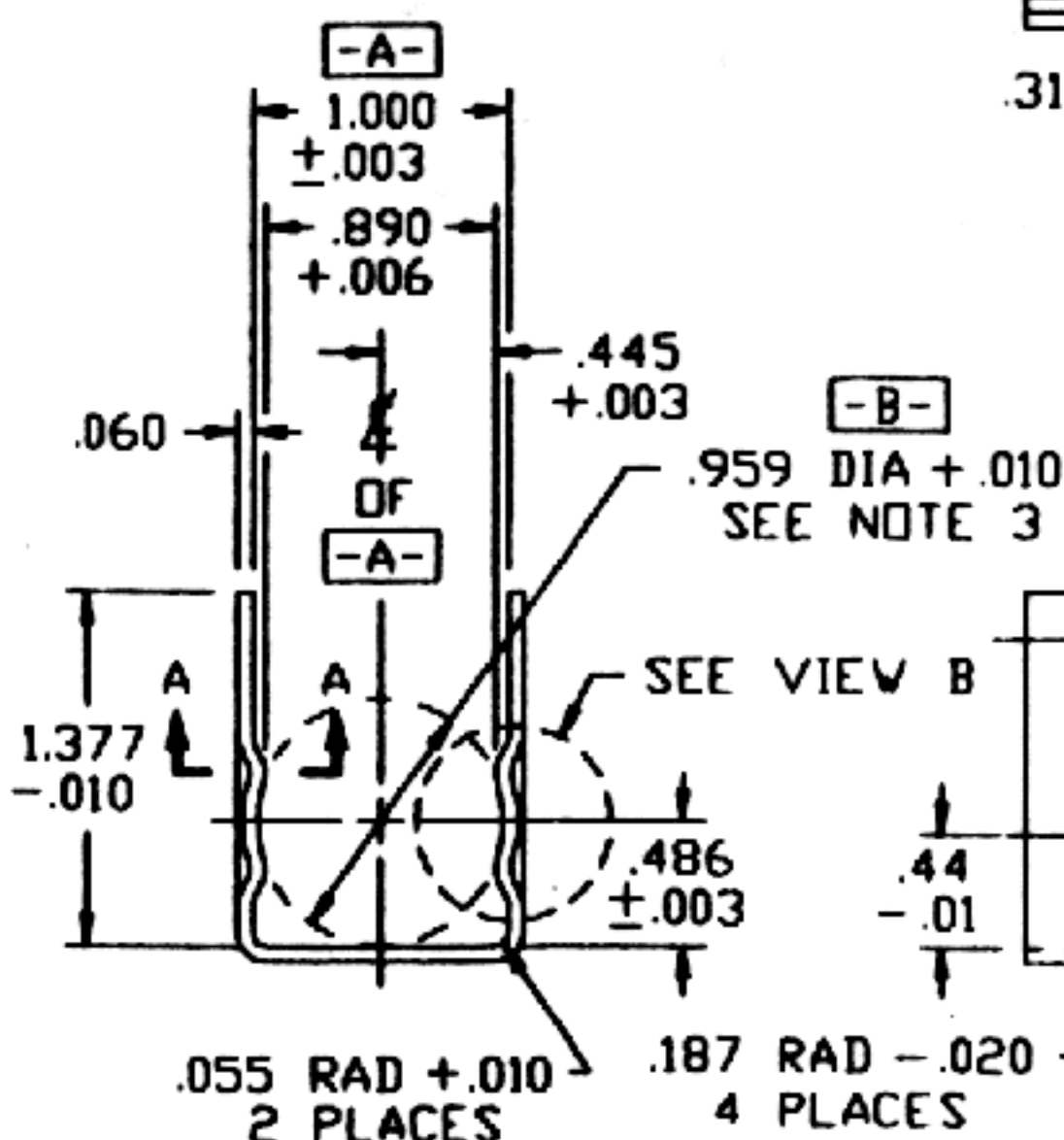
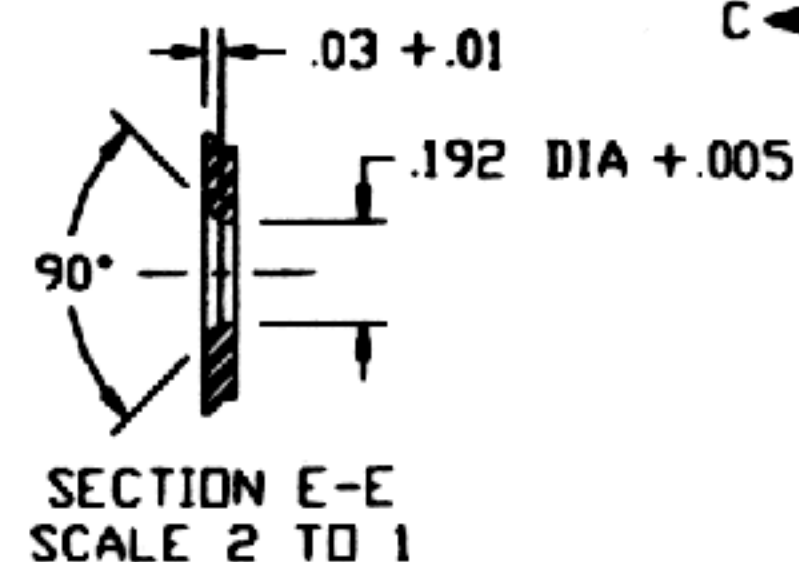
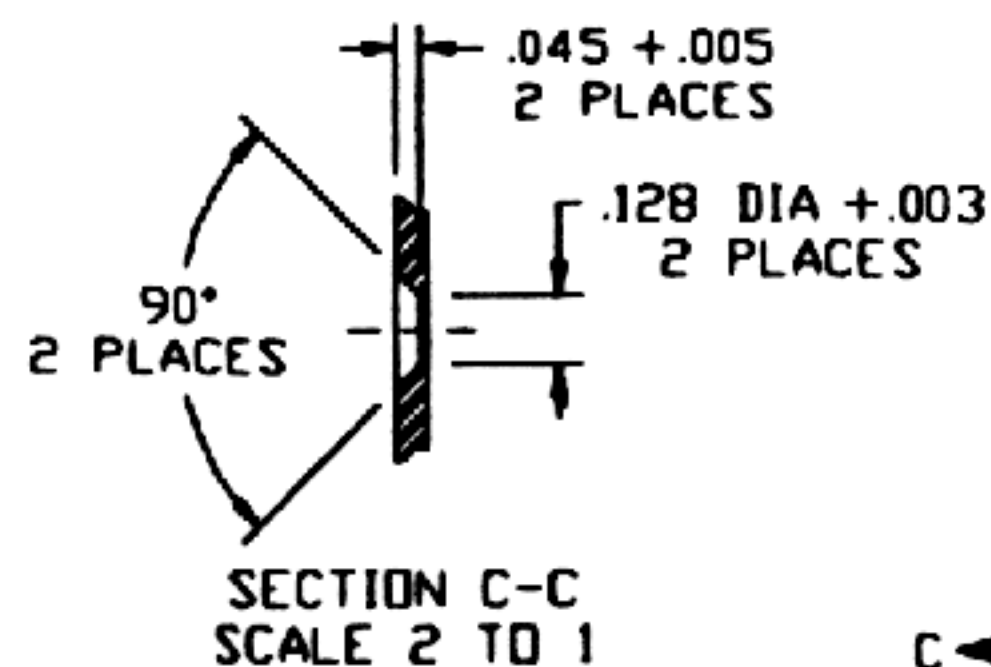
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NEXT ASSEMBLY	F11686308	MG, 7.62 MM - M60, M60C.
	F11699805	M60D

CODE IDENT NO. 19205
DRAWN FROM ORD PART NO. 7269252
SPRINGFIELD ARMORY ORDNANCE CORPS
DEPT OF THE ARMY
SPRINGFIELD 1, MASS

SYM	DESCRIPTION
G	REDRAWN WITH CHANGE SEE EO NO. SA30116
H	(1) SEE EO HRD 82232

SCALE: 2 TO 1	MATERIAL: SEE NOTE 3	CKD.	TOLERANCES
DWN.	FINISH: SEE NOTE 1	DATE	DEC 2 PL ±.02
TITLE: M60 BRIDGE, RECEIVER	REV.		DEC 3 PL ±.005
			ANGLES ±.5°
			NO



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NOTES:

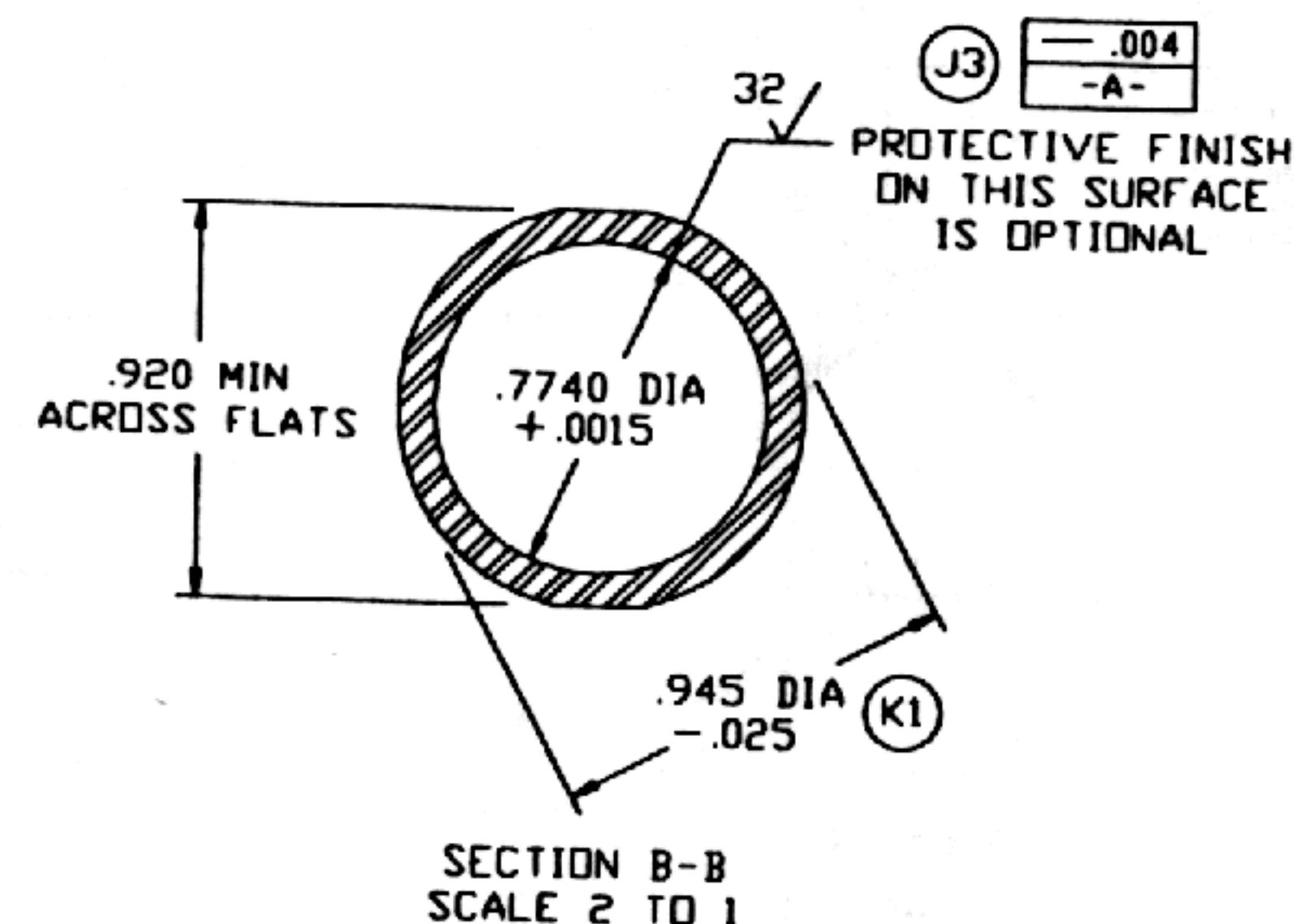
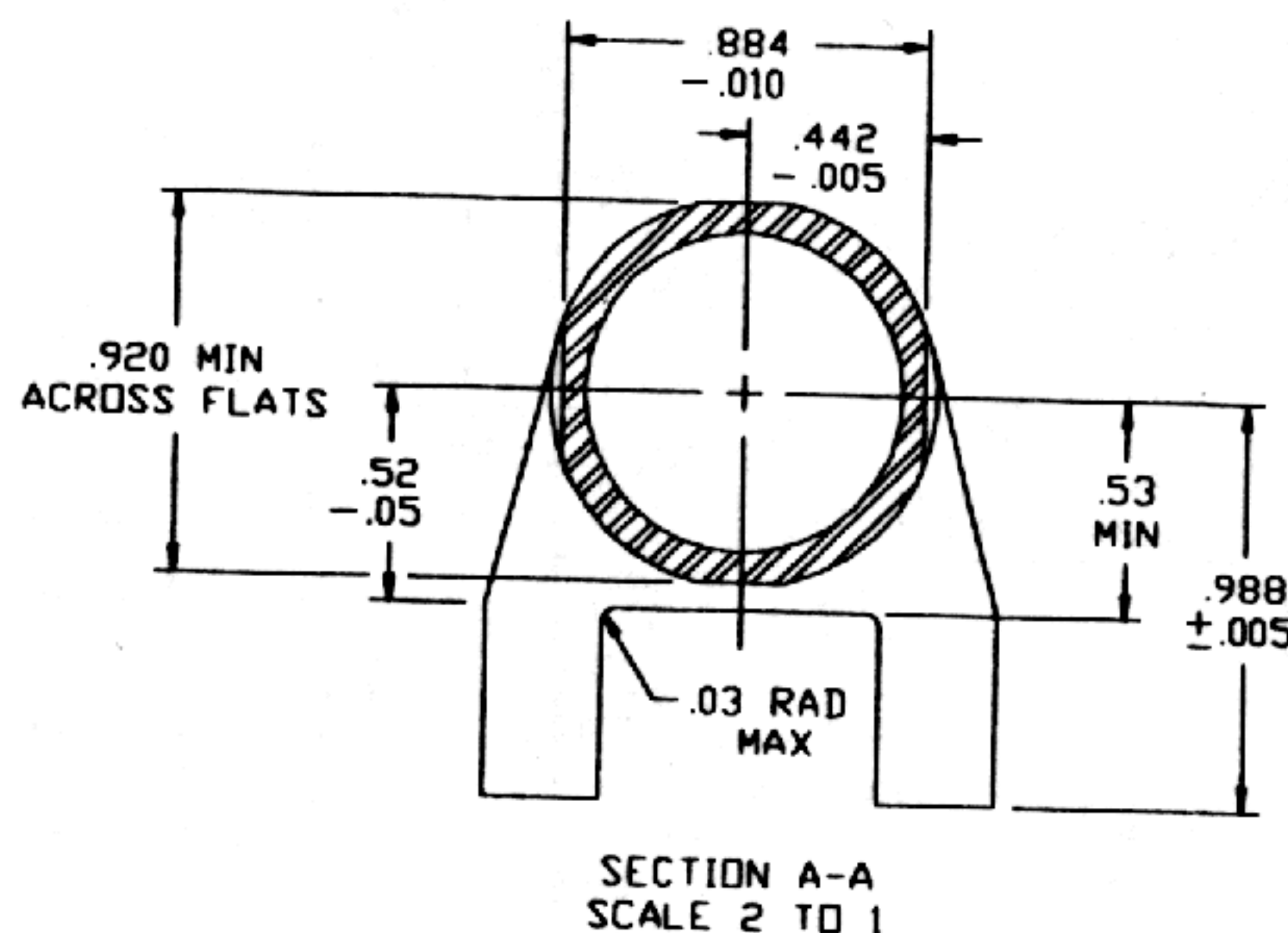
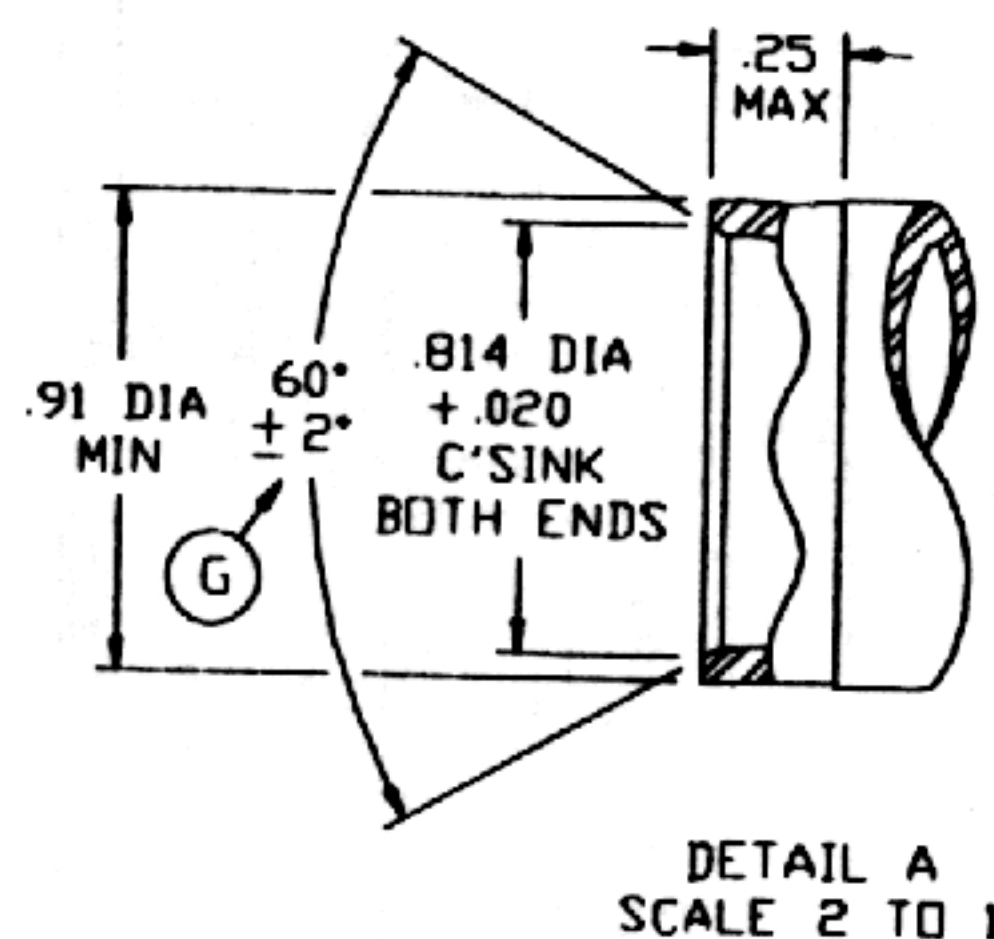
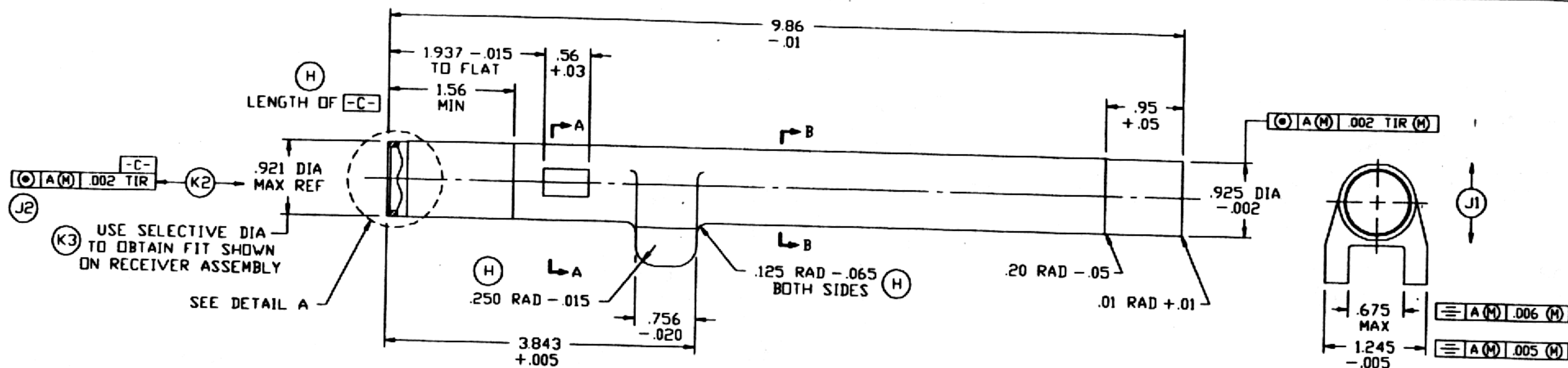
1. FINISH 125/ EXCEPT SHEARED EDGES 250/.
2. ALL EDGES SHALL BE BROKEN .005 +.010 UNLESS OTHERWISE SPECIFIED.
3. [-B-] APPLIES WHEN [-A-] IS MAINTAINED AT 1.00 DATUM.
4. HEAT TREATMENT- HEAT AT 1500° TO 1535°F. OIL QUENCH. TEMPER ONE HOUR TO HARDNESS SPECIFIED HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED. TOTAL AND PARTIAL DECARBURIZATION PERMISSIBLE TO .002 MAX.
5. SEE RECEIVER ASSEMBLY DWG F11686308 AND F11699805 FOR DIA OF HOLE. EACH SIDE.
6. FINISH- 5.3.1.2 OF MIL-STD-171. EXCEPT PARA 3.3 OF MIL-P-16232 SHALL NOT APPLY. (P1)
7. MATERIAL- STEEL QQ-S-777 1060, 1065, 1075.

SYM	DESCRIPTION
M	REDRAWN W/D CHANGE SEE EO NO. SA30121
N	(1-2) SEE EO HRD 82232

NEXT ASSEMBLY	F11686308	MG, 7.62 MM M60	(P2)
	F11699805	M60D	

CODE IDENT NO. 19205
DRAWN FROM ORD PART NO. 7269254
SPRINGFIELD ARMORY ORDNANCE CORPS
DEPT OF THE ARMY
SPRINGFIELD 1, MASS

SCALE: FULL	MATERIAL: SEE NOTE 7	CKD.	TOLERANCES
DWN.	FINISH: SEE NOTE 1	DATE	DEC 2 PL ± .02
TITLE: M60 CHANNEL, RECEIVER	REV.		DEC 3 PL ± .005
			ANGLES ± 5°
			NO.



- NOTES:
1. FINISH $125\sqrt{\text{EXCEPT AS NOTED. FORGED SURFACES } 250\sqrt{\text{INCHES}}$
 2. MATERIAL- STEEL, COMP 4140, SPEC QQ-S-624 (J5) OR COMP 1141, SPEC QQ-S-637, EXCEPT HOT FINISHED 1141 STEEL BARS FOR FORGING PURPOSES, AND ALL OTHER CONDITIONS OF SPECIFICATIONS ARE COMPLIED WITH. (L1)
 3. HEAT TREATMENT- HEAT AT 1525° TO 1575°F. OIL QUENCH. TEMPER 1 HOUR AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
 4. FINAL PROTECTIVE FINISH 5.3.1.2 OF MIL-STD-171

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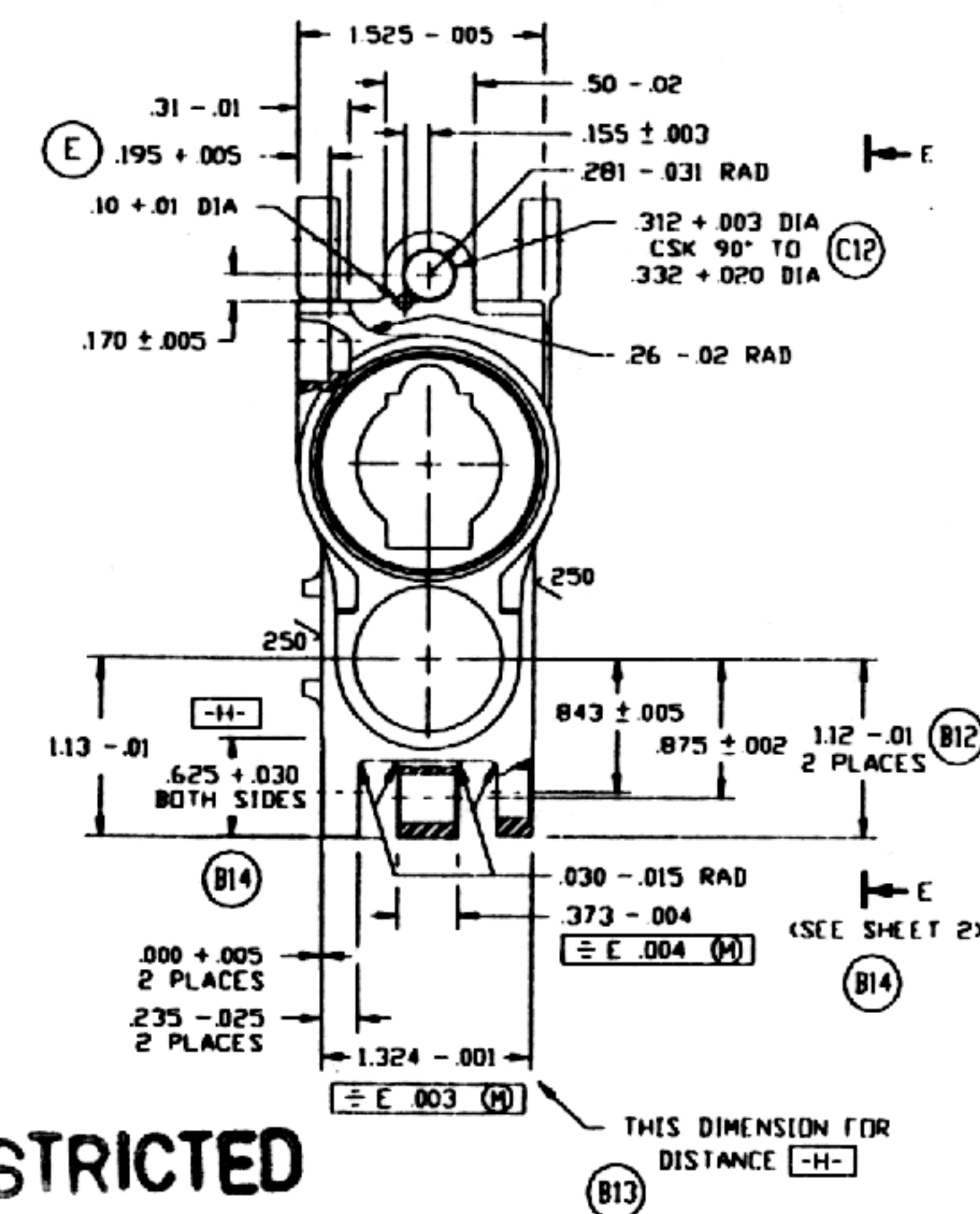
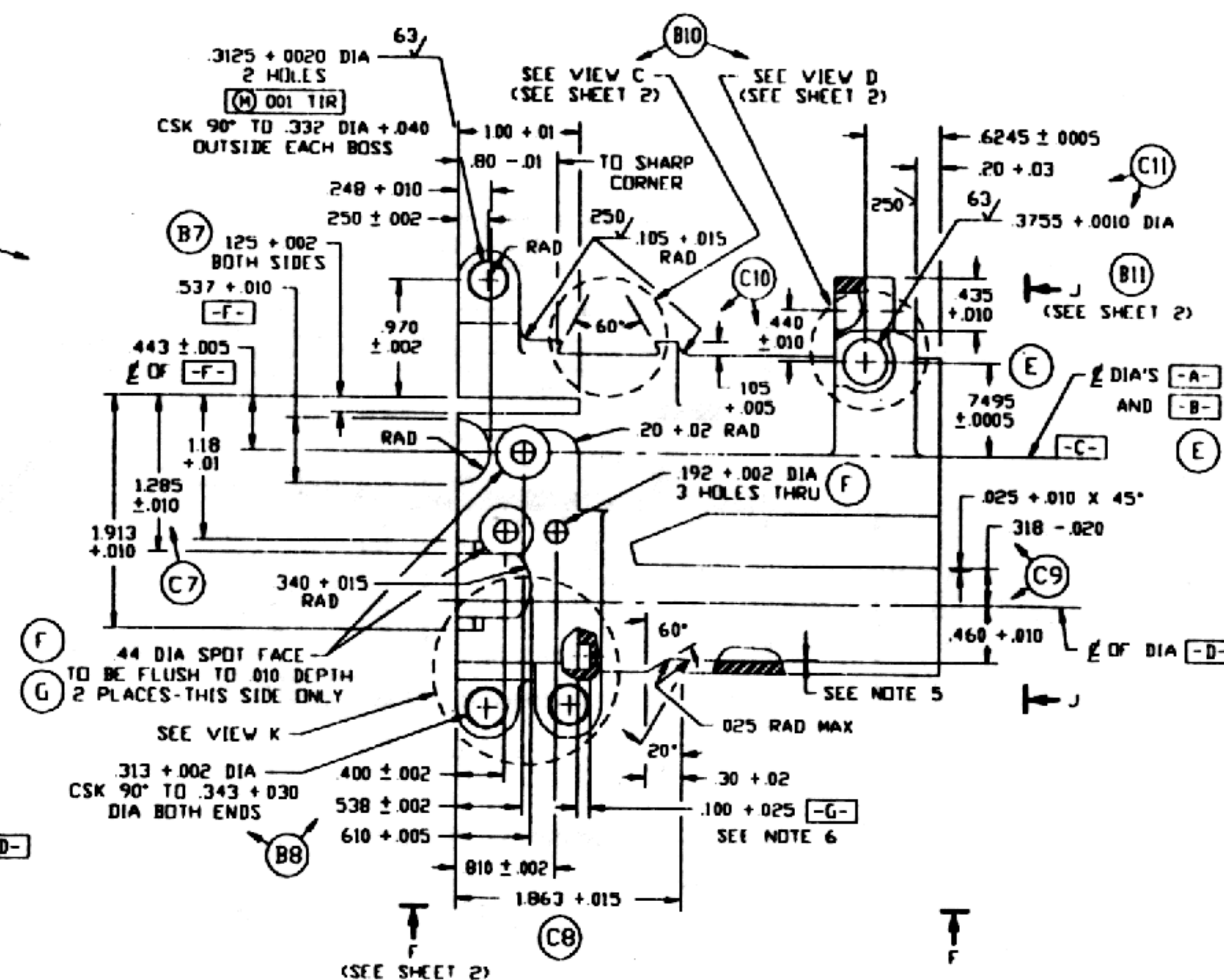
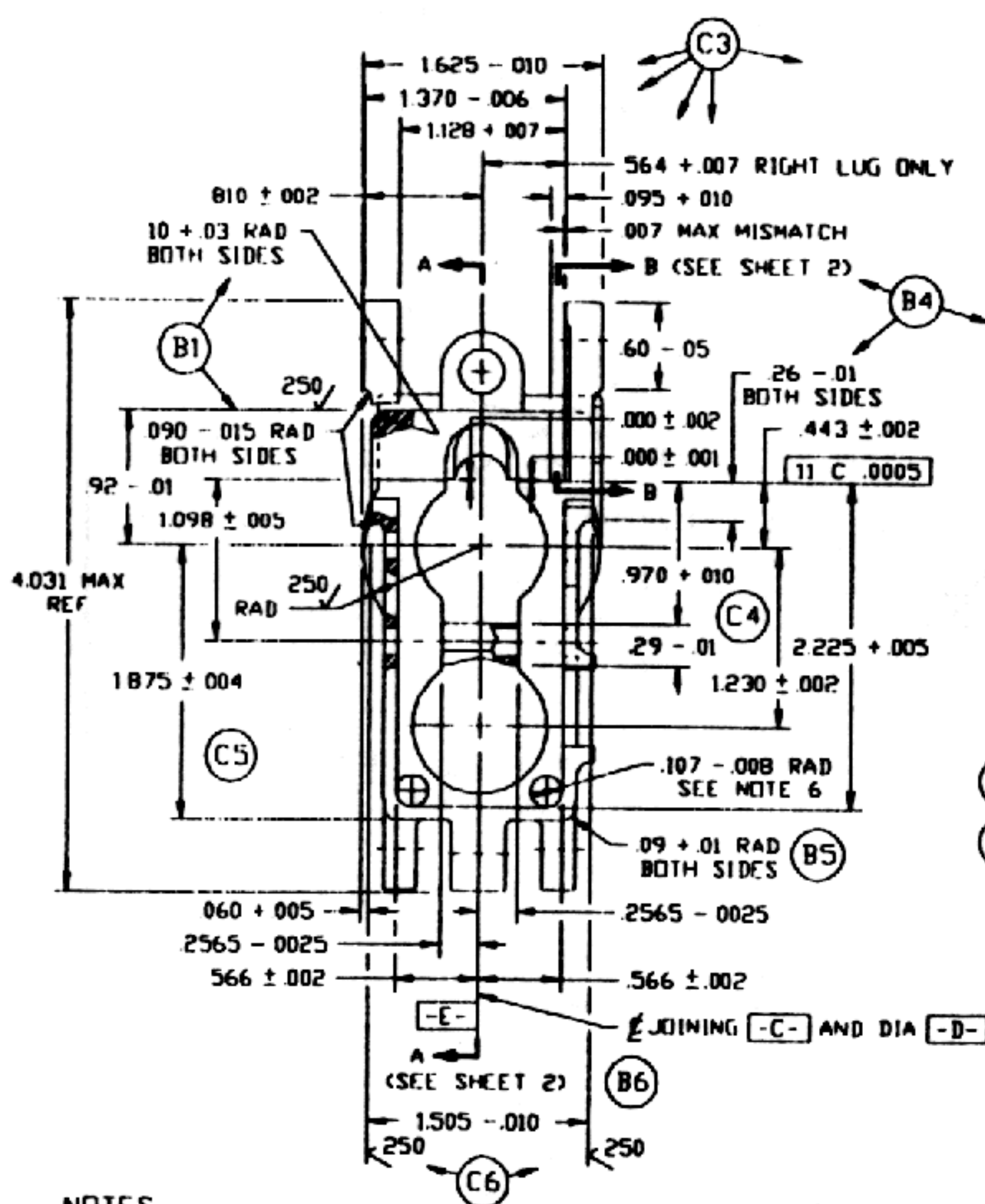
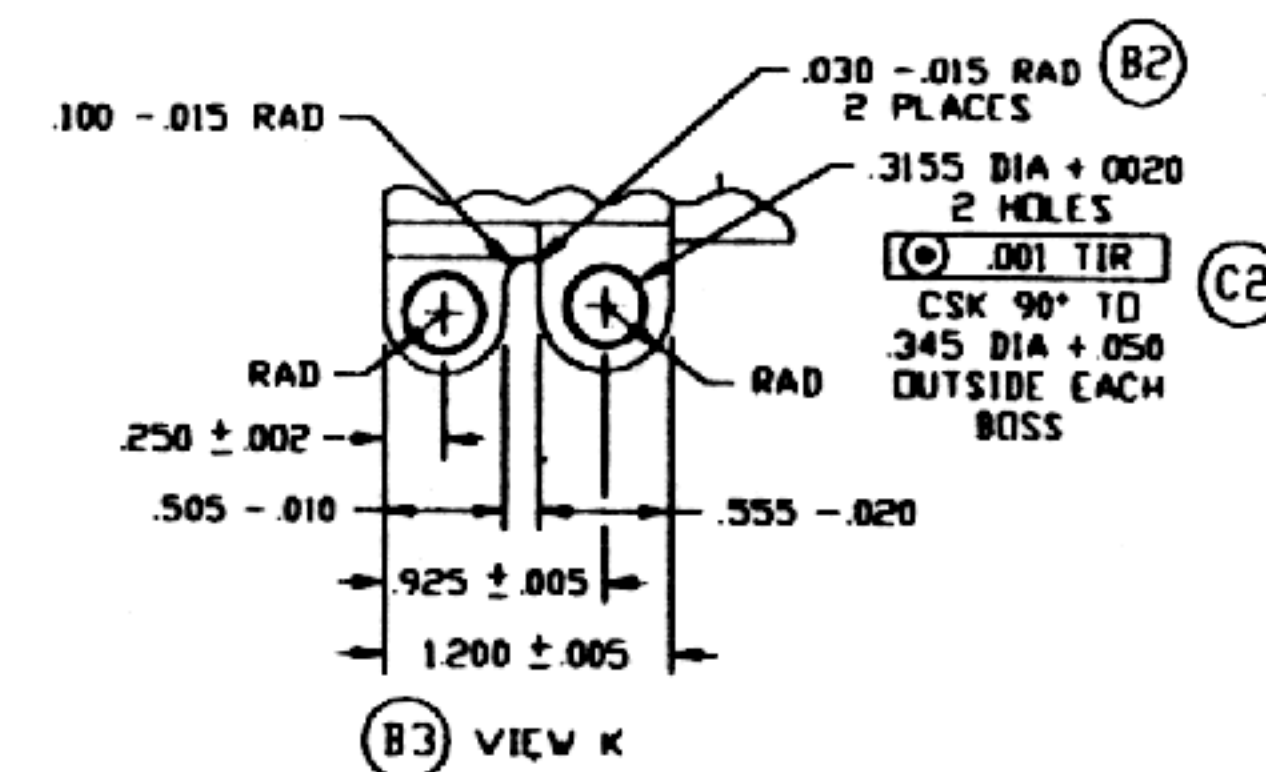
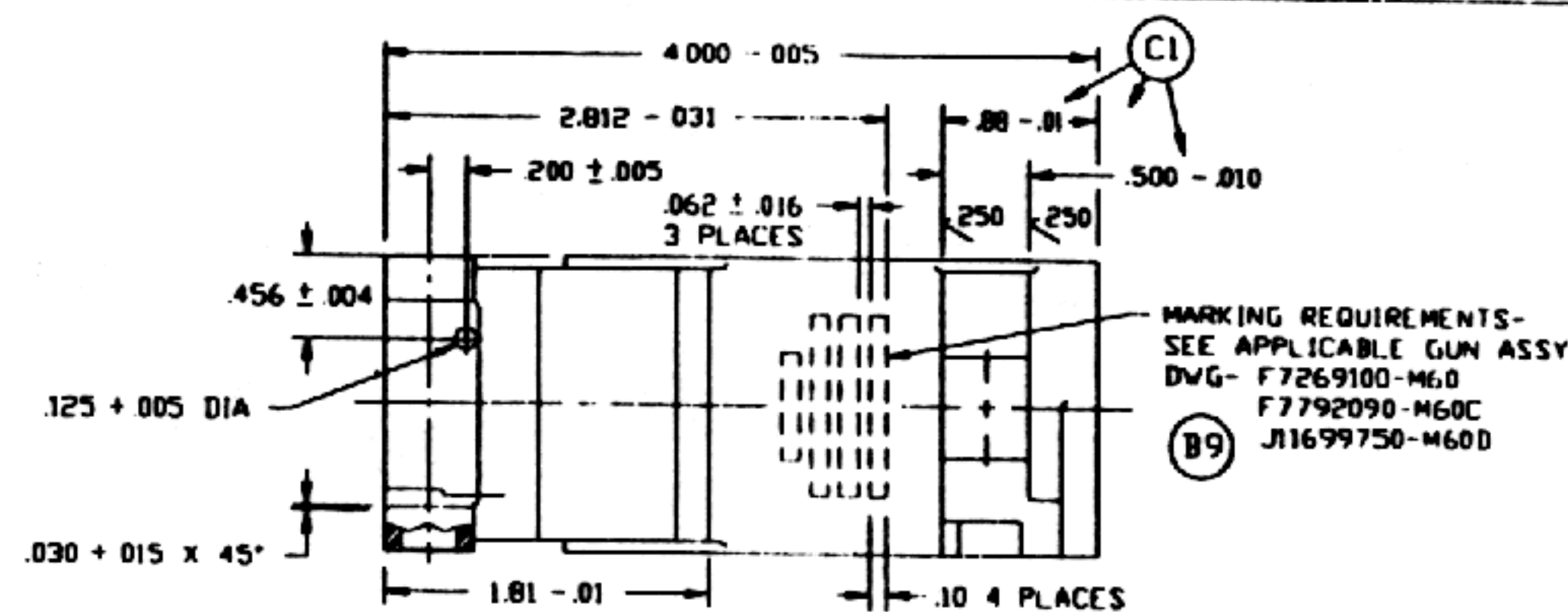
RESTRICTED MATERIAL

SYM	DESCRIPTION
E	
F	REDRAWN & REVISED SEE ED SA26085
G2	REF ED NO. SA27115
H5	REF ED NO. SA27297
J	(1-5) REF ED SA28042
K	(1-3) SEE ED SA29002
L	(1) SEE ED HRD 82370

NEXT ASSEMBLY	F11686308	MG, 7.62 MM - M60, M60C.
	F11699805	M60C

CODE IDENT NO. 19205
 DRAWN FROM ORD PART NO. 7269256 (H)
 SPRINGFIELD ARMORY ORDNANCE CORPS
 DEPT OF THE ARMY
 SPRINGFIELD 1, MASS

SCALE	MATERIAL	CKD	TOLERANCES
FULL	SEE NOTE 2		DEC 2 PL $\pm .02$
DWN	FINISH SEE NOTE 1	DATE	DEC 3 PL $\pm .05$
TITLE	M60	REV.	DEC 3 PL $\pm .127$
GUIDE, OPERATING ROD			ANGLES $\pm 5^\circ$
			NO.



NOTES:

1. FINISH 125/ EXCEPT AS NOTED.
2. ALL EDGES SHALL BE BROKEN .005 ± .010 UNLESS OTHERWISE SPECIFIED.
3. ALL UNSPECIFIED RADII SHALL BE .030 ± .030.
4. HEAT TREATMENT- HEAT AT 1535° TO 1565° F. OIL QUENCH. TEMPER ONE HOUR TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
5. BREAK THRU SHALL BE PERMISSIBLE IN THIS AREA PROVIDED RESULTANT BURRS ARE REMOVED.
6. .215 DIA ± .015 (2) HOLES MAY BE MACHINED IN CORNERS FOR DEPTH -G- TO PROVIDE REQUIRED RADIUS.
7. FINISH 5.3.12 OF MIL-STD-171. (G)
8. ALL RIVET HOLES AND THEIR C'SINKS MAY BE OMITTED (D) OR LEFT UNDERSIZE PROVIDED THEY ARE PUT IN AT ASSEMBLY TO THE DIMENSIONAL REQUIREMENTS AT THE COMPONENT LEVEL.
9. MIL-W-13855 APPLIES. (E)
10. MATERIAL- STEEL QQ-S-624 4140, .0640, .0740.

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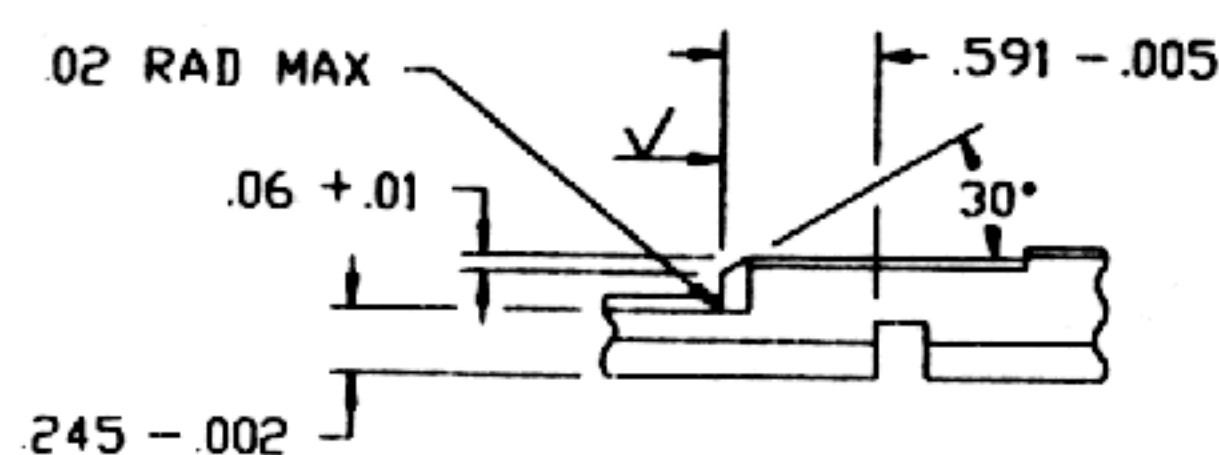
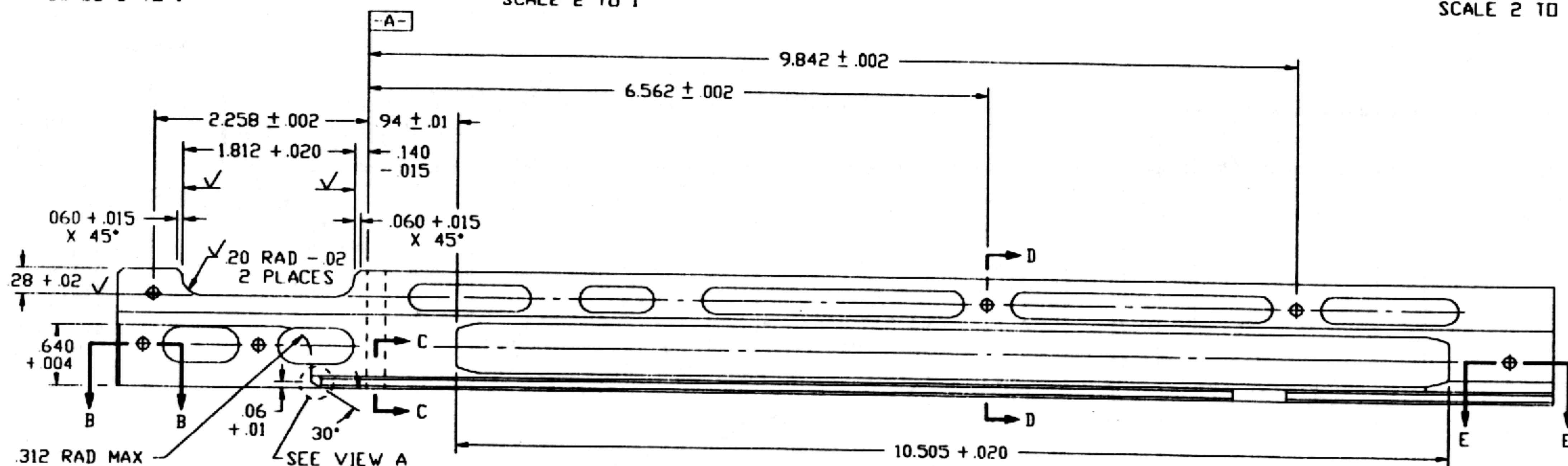
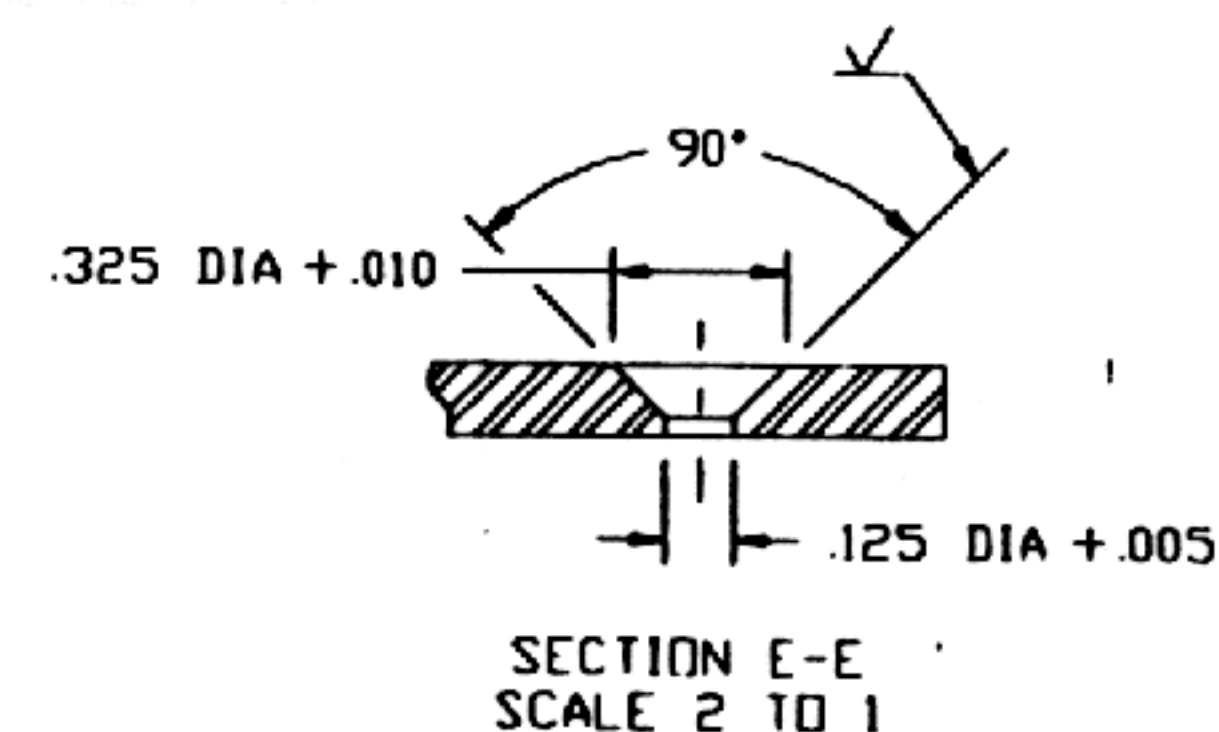
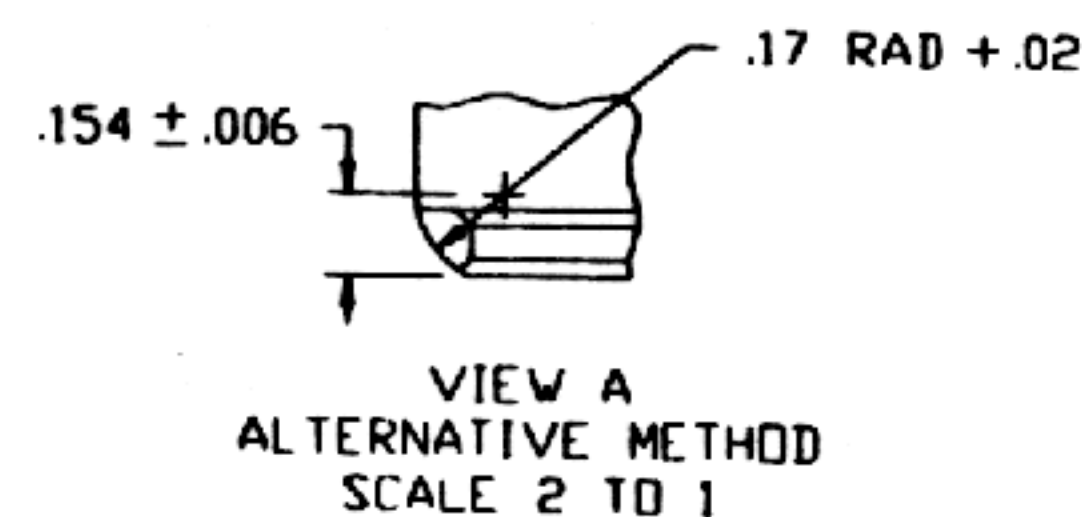
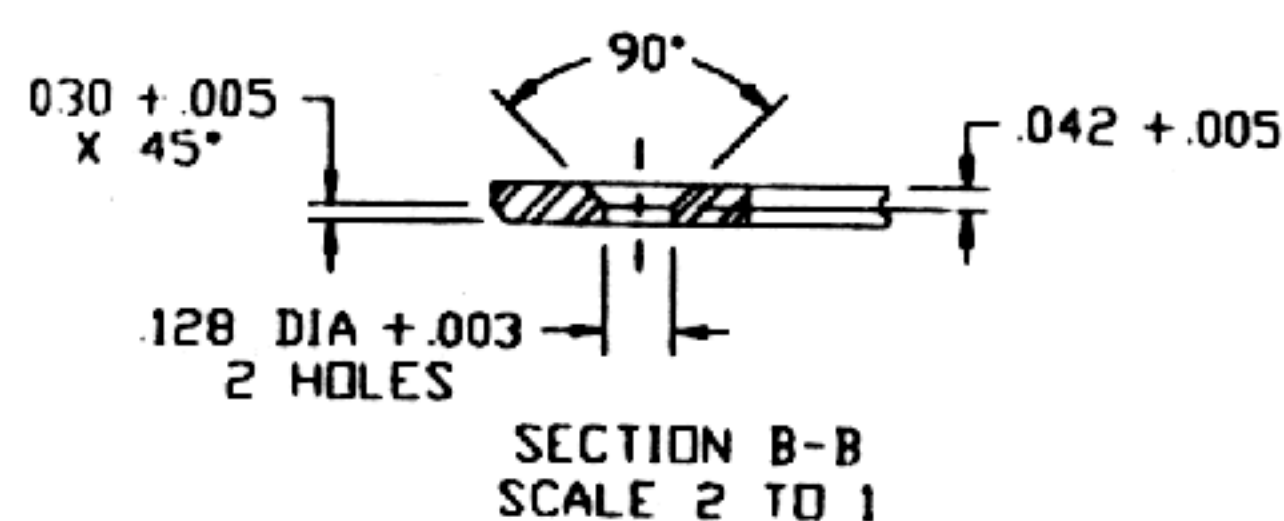
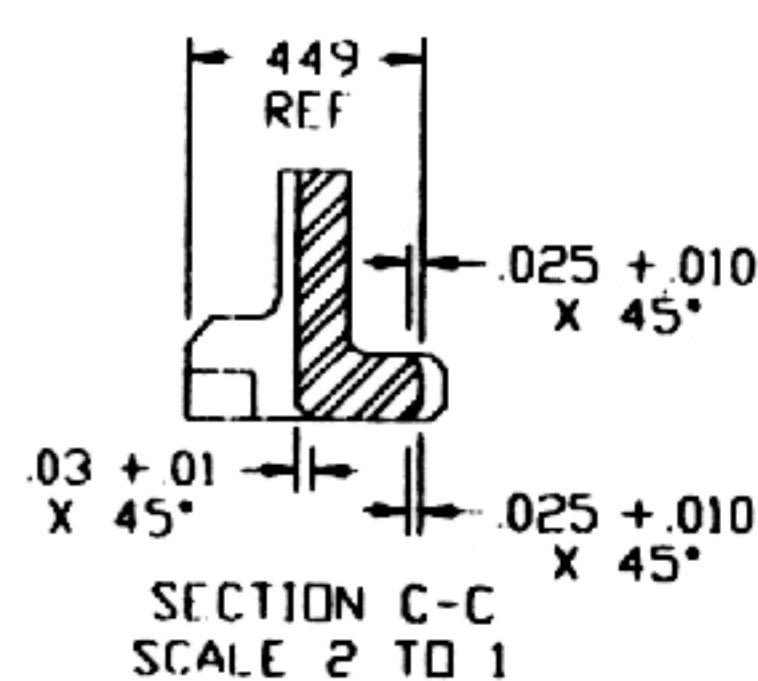
RESTRICTED MATERIAL

NEXT ASSEMBLY	F11686308	MG, 7.62 MM - M60, M60C
	F11699805	M60D

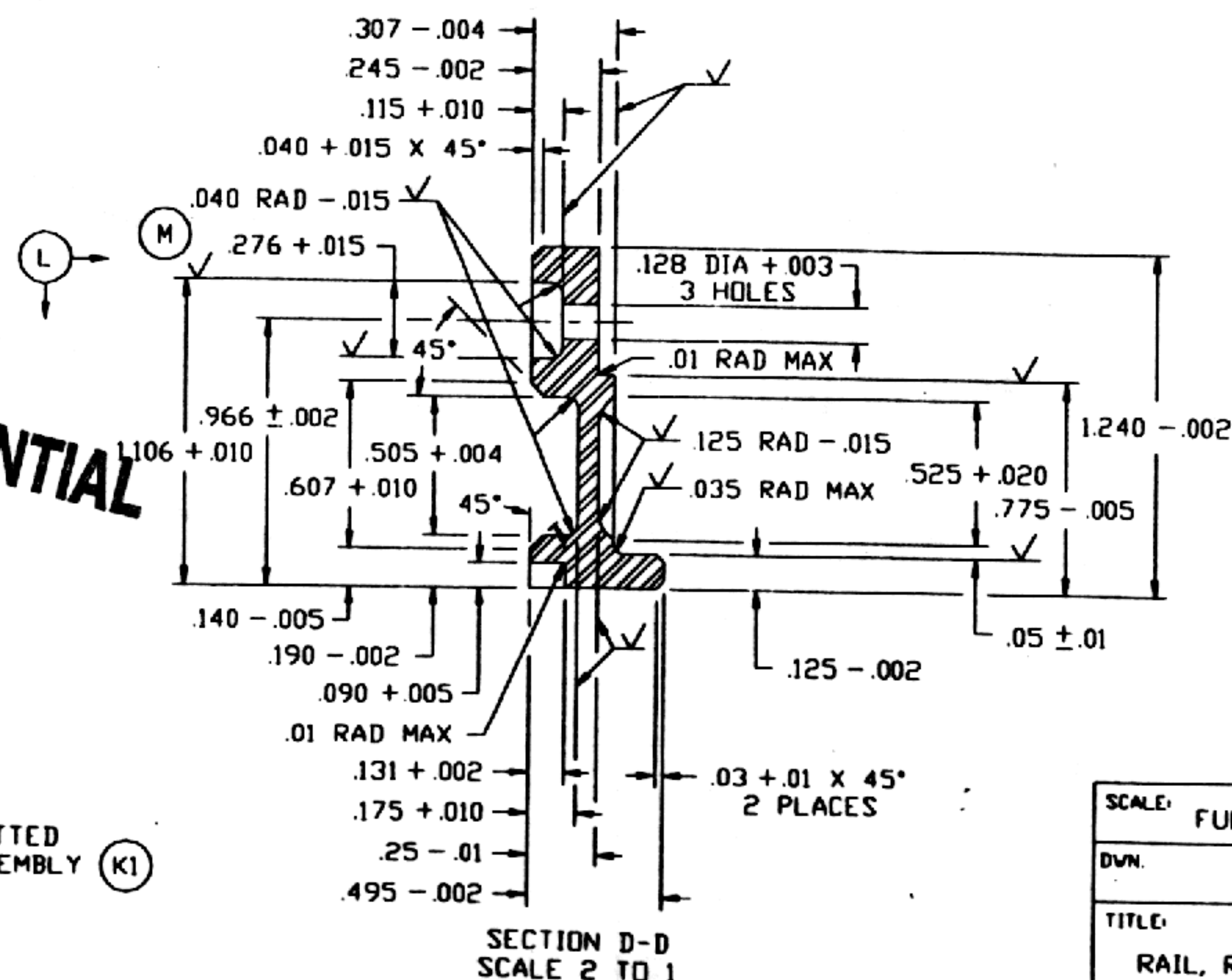
CODE IDENT NO. 19204
DRAWN FROM ORD PART NO. 11686307 SHEET 1 OF 2
ROCK ISLAND ARSENAL
DEPT OF THE ARMY
ROCK ISLAND, ILL.

SYM	DESCRIPTION
A	SEE ED SA29002
B	(1-14) SEE ED SA30032
C	(1-15) SEE ED 82128
D	(1-2) SEE ED HRD 82232
E	(1-4) SEE ERR HDR 10724
F	(2) SEE ERR HDR 30781
G	(2) SEE HDR 75E0036-0002

SCALE: FULL	MATERIAL: SEE NOTE 10	CKD.	TOLERANCES
DWN.	FINISH: SEE NOTE 1	DATE	DEC 2 PL ± .02
TITLE: M60 RECEIVER	REV.		DEC 3 PL ± .005
			ANGLES ± .5°



VIEW F-F
(SEE SHEET 1)



**RESTRICTED
MATERIAL**

SYM	DESCRIPTION
J	REDRAWN WITH CHANGE SEE ED NO. 30122
K	(6) SEE ED HRD 82232
L	(1) SEE ERR HDR 10715
M	SEE ERR HDR 40604

CODE IDENT NO. 19204
DRAWN FROM ORD PART NO. 7269258
ROCK ISLAND ARSENAL
DEPT OF THE ARMY
ROCK ISLAND, ILL

NOTE:
ALL RIVET HOLES AND THEIR COUNTERSINKS MAY BE OMITTED
OR LEFT UNDERSIZE PROVIDED THEY ARE PUT IN AT ASSEMBLY
TO THE DIMENSIONAL REQUIREMENTS APPLICABLE
AT THE COMPONENT LEVEL. (K1)

SCALE: FULL	MATERIAL: SEE SHEET 1	CKD.	TOLERANCES
DWN.	FINISH: SEE SHEET 1	DATE	DEC 2 PL ±.02 M H ±.31
TITLE: M60 RAIL, RECEIVER, LEFT HAND	REV.	NO.	DEC 3 PL ±.005 M H ±.127 ANGLES ± 5°

LIST OF PARTS SUPPLIERS

wholesale guns and ammo, inc.
232 blydenburgh rd.
central islip, NY 11722

www.gunsnammo.com

international military antiques , inc.
p.o.box 256 millington ,NJ 07946

www.ima-usa.com

inter ordnance of america l.p.
3305 westwood industrial drive
monroe , NC 28110

www.inter-ordnance.com

sarco , inc.
323 union st. p.o. box 98
stirling , NJ 07980

jeffs shooters supply
p.o.box 1054 trussville , AL 35173

rpb industries
p.o.box 367 avondale est. GA 30002